

Date: Friday, 30/11/2007 1:13:46 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LEG
Job Number : 36086	
Estimate Number : 12511	
P.O. Number : <i>NA</i>	Part Number : D35231
This Issue : 30/11/2007 S.O. No. : <i>NA</i>	Drawing Number : D3523 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NA</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 34802	Material : <i>NA</i>
Written By : <i>[Signature]</i>	Due Date : 07/12/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>10</i> Um: Each
Comment : Est Rev:A New Issue 06-08-21 EC Est Rev:B Added Helicoil 07-07-19 JLM Verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1218 f(s)/Unit Total: 0.9744 f(s)

6061-T6 round bar 1.00"

(M6061T6 round bar 1.00")

Batch: *1018147*

*USED 1.461 FT*

*06 M18147*

*[Signature] 07/11/30*

*(10)*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA697 & dwg D3523

*[Signature] 07/11/30*

*(10)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature] 07/11/30*

*(10)*

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Drill For Helicoil & Set-Screw

*RD 07/02/01*

*(10)*

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*RD 07/12/07*

*(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/2/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 1:13:46 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 36086

Part Number: D35231

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07-12-03 10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

07-12-03 10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10X 07/12/05

9.0

MS21209F120

HELI COIL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

HELI COIL

Batch: M104996

07/12/14

10.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg D3523

07/12/14

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02.12.14 10

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 101

7/12/17 50 10X

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11 07/12/18

Job Completion



min 2007/12/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

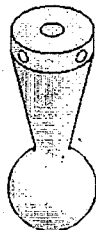
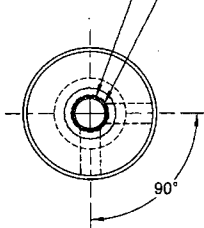
3

2

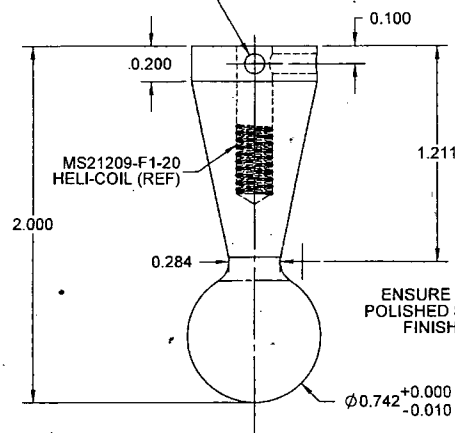
1

DRILL #7 ( $\phi 0.201$ ) x 0.83 DEEP  $\triangle B$   
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)

INSTALL MS21209-F1-20 HELI-COIL  
TO THE BOTTOM OF THE HOLE



DRILL #33 ( $\phi 0.113$ )  
TAP #6-40 UNF  
(2 PLACES)



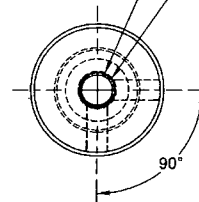
R0.13

ENSURE SMOOTH,  
POLISHED SURFACE  
FINISH ON BALL

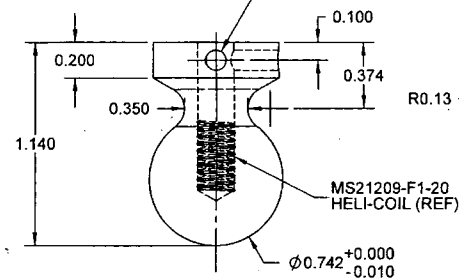
**D3523-1 LEG**

DRILL #7 ( $\phi 0.201$ ) x 0.83 DEEP  $\triangle B$   
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)

INSTALL MS21209-F1-20 HELI-COIL  
TO THE BOTTOM OF THE HOLE



DRILL #33 ( $\phi 0.113$ )  
TAP #6-40 UNF  
(2 PLACES)



R0.13

ENSURE SMOOTH,  
POLISHED SURFACE  
FINISH ON BALL

**D3523-3 LEG**

**RELEASED**  
07.08.03

$\triangle B$

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3523-1: 0.05 lbs  
D3523-3: 0.03 lbs

B	ZONE D7, D3: HOLE DEPTH REVISED FROM 0.69 TO 0.83 ZONE A8: UPDATE NOTES, ADD WEIGHT UPDATE DRAWING FORMAT	CB	07.07.25
A	NEW ISSUE	CB	07.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	E	<b>D3523</b>	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	#	<b>LEG</b>	3:2
DATE	07.07.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

*W/O 55952*



